Work Order ID 95886

95886

January-21-13 9:13:58 AM

Item ID: D4635-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Fwd Ceiling Panel Assembly, LH

Start Date: 1/16/13 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 1/30/13 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** MLS **Date:** 13-01-23 **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4635	A REJB DL 13/04/10.								
100		0.00							
100						XI		JB 13/04/10	
HandThermo	**Memo**	0.00							
Hand Finishing Thermoforming	Pick Kit								
110		0.00							
110						x1		DL 13/04/10	
Small Fab	**Memo**	0.00							
Small Fab	1- Assemble as per Dwg D4635-041								
	2-Install speakers								
	3- Install Air valves								
	4-Install Wiring Harness								
	5-Install wiring harness								

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Work Order Update	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Item ID: D4635-041 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fwd Ceiling Panel Assembly, LH
Start Date: 1/16/13 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 1/30/13 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00	DAS 16 8-89			+1			
120 QC Quality Control	**Memo**	0.00				LH			
130	Identify as per dwg & Stock Location:_____	0.00							
130 Packaging Packaging	**Memo** PP99482	0.00							
140	QC21- Final Inspection - Work Order Release	0.00							
140 QC Quality Control	**Memo**	0.00							

13/04/17
13/9/22
13/4/24
MF
13-4-24

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

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- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

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- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

January-21-13 9:13:58 AM

Work Order ID: 95886

Parent Item: D4635-041 **Start Date:** 1/16/13 **Required Date:** 1/30/13

Parent Item Name: Fwd Ceiling Panel Assembly, LH **Start Qty:** 1.00 **Required Qty:** 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Doc Release DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
~~D4635-1~~ Fwd Ceiling Panel, LH	D4635-141 DL	Manufactured	No	98236		100	Each	0.0000	1	1			DAS 07 9-89 13/04/17
D4646-1 Plenum Cap Assembly		Manufactured	No			100	Each	24.0000	2	2			68 20 SAD 13/04/17
				Location		**Loc Qty**		**Loc Code**					
				ST117		24							
				92968		24				2			
D4652-1 Air Valve, 1.16 ID Disk Type		Manufactured	No			100	Each	24.0000	2	2			DAS 07 9-89 13/04/17
				Location		**Loc Qty**		**Loc Code**					
				ST117		24							
				93032		24				2			
D4655-1 Speaker		Manufactured	No			100	Each	14.0000	2	2			DAS 07 9-89 13/04/17
				Location		**Loc Qty**		**Loc Code**					
				st113	92333	14							
				~~93061~~		14				x2			
D4743-1 DL ~~D4655-3~~ Speaker Grill		Manufactured	No	93142		100	Each	0.0000	2	x2			DAS 07 9-89
~~D4664-3~~ Spacer	N/A DL	Manufactured	No			100	Each	100.0000	16	16			13/04/17
				Location		**Loc Qty**		**Loc Code**					
				ST117		100							
				93070		100							
~~D4669-1~~ Bracket	N/A DL	Manufactured	No			100	Each	0.0000	2	2			
~~D4695-041~~ Channel Assembly	N/A DL	Manufactured	No			100	Each	0.0000	1	1			

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Work Order Update	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐	Engineering	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐	Quality	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Large Fab	☐	Composite	☐	Supplier	☐		☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐	Bending
☐	Centre Not Concentric to O/S
☐	Cracks
☐	Crushed/Crimped
☐	Cuffs
☐	Heat Treat
☐	Inspection Strip in Tube
☐	Ripples in Bend
☐	Torque Waves in Extrusion
☐	Turning Sequence
☐	Wave/Twist in Tube

General

☐	Bend	☐	Grain	☐	Ovalized
☐	BOM/Route	☐	Hardware	☐	Over/Under tolerance
☐	Broken/Damaged	☐	Inspection Incomplete	☐	Part Incorrect
☐	Burrs	☐	Instructions Incomplete/Unclear	☐	Part Lost/Missing
☐	Contamination	☐	Maintenance	☐	Part Moved
☐	Countersink	☐	Mislabeled	☐	Positioned Wrong
☐	Cut Too Short	☐	Misread	☐	Power Loss/Surge
☐	Drill Holes	☐	Offset		
☐	Drawing	☐	Out of Calibration		
☐	Finish	☐	Out of Sequence		
☐	Folio	☐	Outside Dimensions		

☐	Pressure/Forced
☐	Temperature/Cure
☐	Weld
☐	Wrong Stock Pulled
☐	Other

Work Order ID: 95886

Parent Item: D4635-041 **Start Date:** 1/16/13 **Required Date:** 1/30/13

Parent Item Name: Fwd Ceiling Panel Assembly, LH **Start Qty:** 1.00 **Required Qty:** 1.00

D4708-9 Lanyard	Manufactured	No		100	Each	24.0000	**2**	**2**

Location	Loc Qty	Loc Code
ST118	24	
92290	12	
93919	12	

DAS 07 9-89 13/04/17

D4728-041 LH Cabin Speaker #1	Manufactured	No		100	Each	2.0000	**1**	**1**

Location	Loc Qty	Loc Code
ST120	2	
93445	2	

DAS 07 9-89 13/04/17

D4728-043 LH Cabin Speaker #2	Manufactured	No		100	Each	2.0000	**1**	**1**

Location	Loc Qty	Loc Code
ST120	2	
93449	2	

DAS 07 9-89 13/04/17

D4728-059 Cabin Lights Harness	Manufactured	No		100	Each	2.0000	**1**	**1**

Location	Loc Qty	Loc Code
ST120	2	
93460	2	

DAS 07 9-89 13/04/17

~~**D4732-29**~~ ~~Label~~ N/A DL	Manufactured	No		100	Each	10.0000	**1**	**1**

Location	Loc Qty	Loc Code
ST120	10	
93213	10	

~~**D4732-33**~~ ~~Label~~ N/A, DL	Manufactured	No		100	Each	10.0000	**1**	**1**

Location	Loc Qty	Loc Code
ST120	10	
93291	10	

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Work Order Update	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

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General

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- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

January-21-13 9:13:58 AM

Work Order ID: 95886
Parent Item: D4635-041
Parent Item Name: Fwd Ceiling Panel Assembly, LH

Start Date: 1/16/13 **Required Date:** 1/30/13
Start Qty: 1.00 **Required Qty:** 1.00

D4732-5 N/A DL Label	Manufactured	No		100	Each	10.0000	1	1

Location	Loc Qty	Loc Code	
ST120	10		
93221	10		

D4732-9 N/A DL Label	Manufactured	No		100	Each	10.0000	1	1

Location	Loc Qty	Loc Code	
ST120	10		
93176	10		

MPNY-750S-9-C N/A. DL Mounting Pad	Purchased	No		100	Each	100.0000	6	6

Location	Loc Qty	Loc Code	
ST390	100		
124058	100		

MS21042L08 N/A DL Nut	Purchased	No		100	Each	4,179.0000	8	8

Location	Loc Qty	Loc Code	
ST315	4179		
122141	3		
122452	9		
122814	500		
123900	3667		

MS21044-N08 Nut	Purchased	No		100	Each	200.0000	8	8

Location	Loc Qty	Loc Code	
ST316	200		
123741	200		8

DAS 07 9-89
13/07/17

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Work Order Update	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Mislabeled
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- ☐ Weld
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- ☐ Other _____

Work Order ID: 95886
Parent Item: D4635-041
Parent Item Name: Fwd Ceiling Panel Assembly, LH

Start Date: 1/16/13 **Required Date:** 1/30/13
Start Qty: 1.00 **Required Qty:** 1.00

MS21919-WDG8 Clamp	Purchased	No		100	Each	66.0000	6	6

Location	Loc Qty	Loc Code
ST322	66	
100202	6	
123900	60	

DAS 07 9-89 13/04/17

~~MS24694-S7~~ MS24693-BB51 Screw	Purchased	No		100	Each	100.0000	8	8

Location	Loc Qty	Loc Code
ST302 124204	100	
~~123741~~	100	

DAS 07 9-89 13/04/17

NAS1149DN832J WASHER	Purchased	No		100	Each	2,256.0000	24	24

Location	Loc Qty	Loc Code
ST293	1856	
123248	24	
123348	632	
123352	200	
123603	400	
123900	600	
ST509	400	
124093	400	

DAS 07 9-89 13/04/17

PLT1.5M-M Tie Wrap	Purchased	No		100	Each	0.0000	6	6

124363

DAS 07 9-89 13/04/17

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
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Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

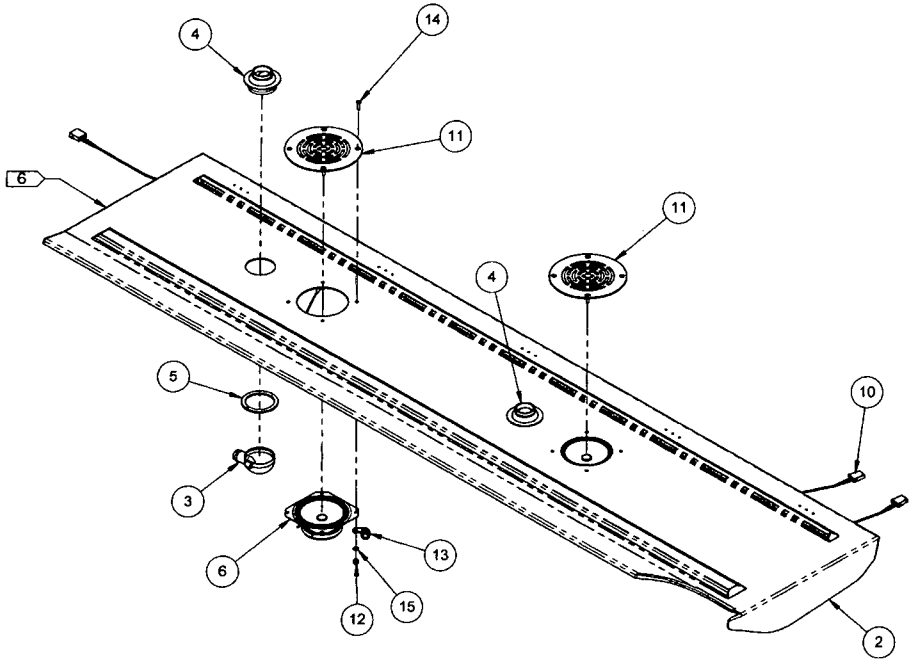
FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
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- ☐ Grain
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- ☐ Maintenance
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- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other



ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4635-041	LH, FWD CEILING PANEL ASSY
2	1	D4635-141	LH, FWD CEILING REPLACEMENT PANEL ASSY
3	2	D4646-1	PLENUM CAP ASSEMBLY 92968
4	2	D4652-1	AIR VALVE 93032
5	2	D4652-3	MOUNTING NUT
6	2	D4655-1	SPEAKER 92333
9 7	2	D4708-9	LANYARD 92290
8	1	D4728-041	LH SPEAKER #1 HARNESS ASSEMBLY 93445
9	1	D4728-043	LH SPEAKER #2 HARNESS ASSEMBLY 93449
10	1	D4728-059	CABIN LIGHT HARNESS 93460
B 11	2	D4743-1	SPEAKER GRILL 93142
12	8	MS21044-N08	NUT 123741
13	6	MS21919WDG8	CLAMP 123900
B 14	8	MS24693-BB51	SCREW 124204
15	8	NAS1149DN832J	WASHER 123248
16	7	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C) 124363

RELEASED
2013 -01- 30

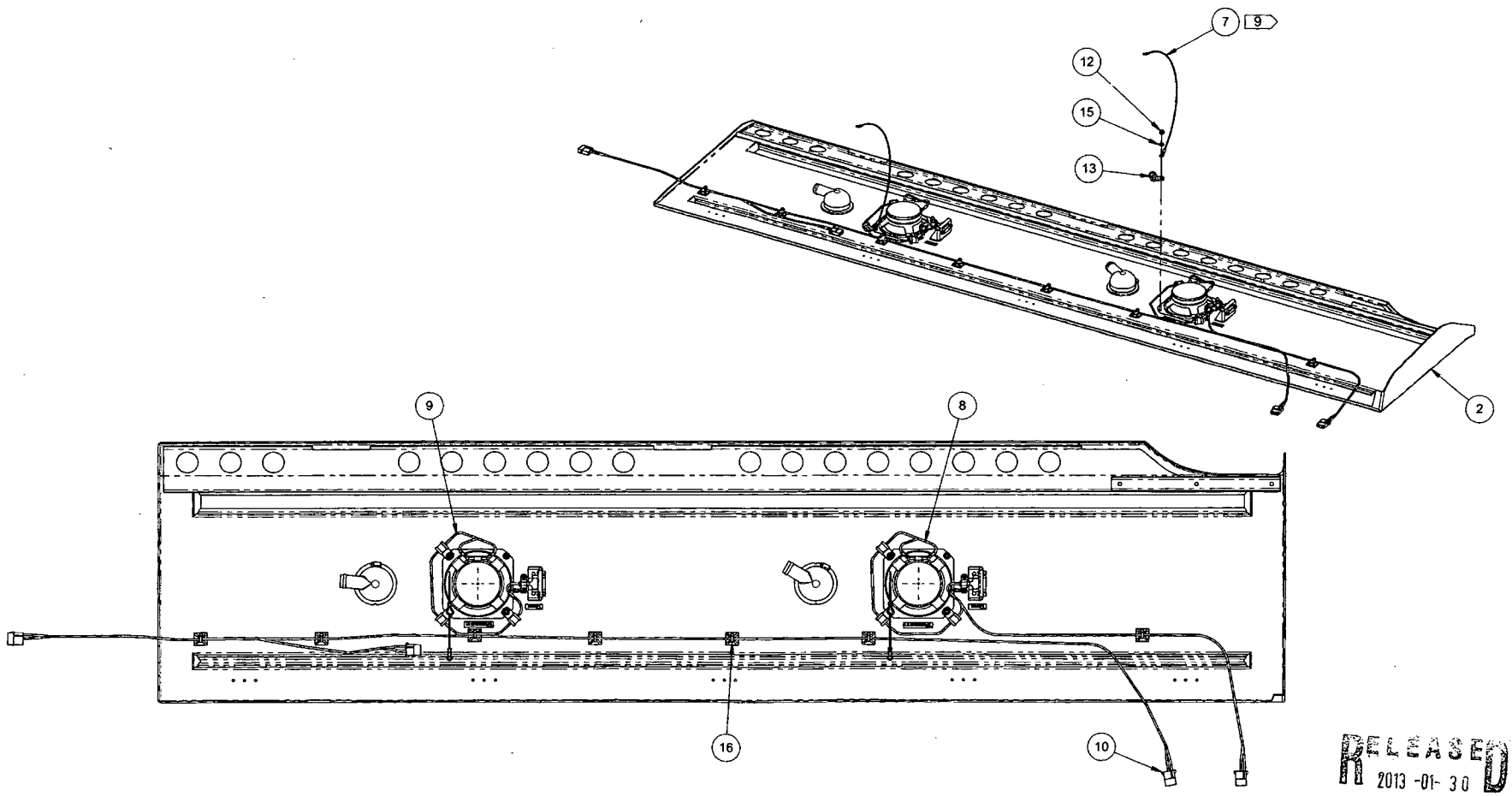
D4635-041 LH, FWD CEILING PANEL ASSY

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
7) WEIGHT: 7.8 lbs
8) INSTALL D4728-041/-043/-059 WIRE HARNESS PER QSI 048
9) ON D4708-9 LANYARD OPEN TO ∅0.196 BOTH ENDS

REV.	DESCRIPTION	BY	DATE
B	ADDED D4635-141/-142/-143/-144 (ZN B4-9, B4-10, B4-11, B4-12); REVISE D4635-041/-042/-043/-044 PART LIST & GENERAL NOTES; ADDED D4732-41 (ZN B5-8); CHANGE TO D4743-1 SPEAKER GRILL AND MS24693-BB51 SCREWS (SHT 1, 3, 5, 7); ADD VIEWS R'-R' (ZN A7-17) AND S'-S' (ZN A5-17); UPDATE DETAIL 'D' (ZN C7-18)	RF	12.11.30
A	NEW ISSUE	RF	12.07.25

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4635	SHEET 1 OF 18
APPROVED		TITLE	SCALE
DE APPR.		OUTBOARD CEILING PANELS	NTS
DATE	12.11.30		

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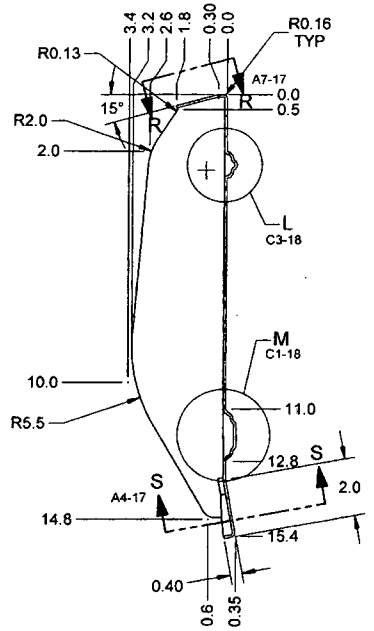


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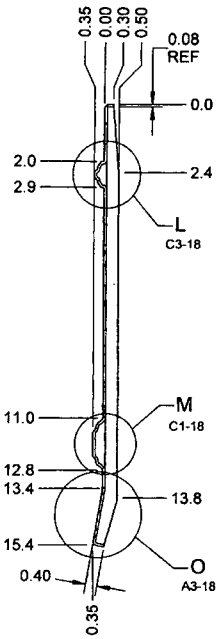
D4635-041 LH, FWD CEILING PANEL ASSY
AUXILIARY VIEW

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DRAWN	RF	
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MFG. APPR.		D4635 SHEET 2 OF 18
APPROVED		TITLE SCALE
DE APPR.		OUTBOARD CEILING PANELS NTS
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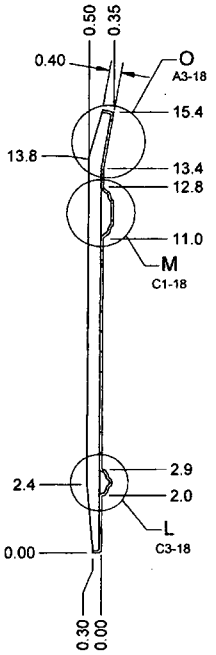
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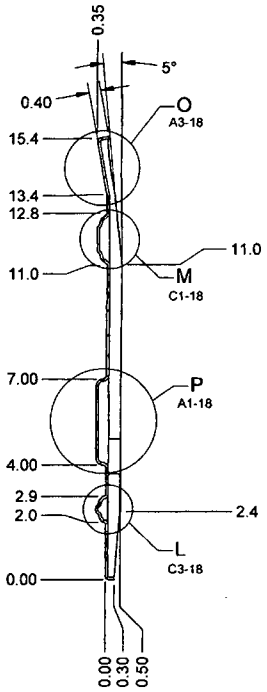
SECTION A-A
SECTION A'-A' OPPOSITE B3-13 B3-14
SCALE 2X



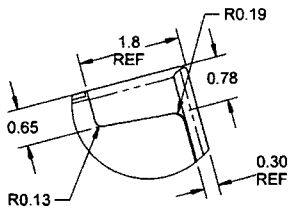
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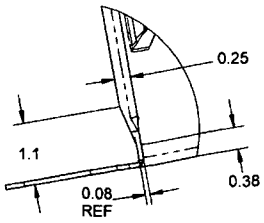
SECTION G-G B4-15 B4-16
SCALE 2X



SECTION K-K C6-16
SCALE 2X



AUXILIARY VIEW R-R D7-17
SECTION R'-R' OPPOSITE
SCALE 2X

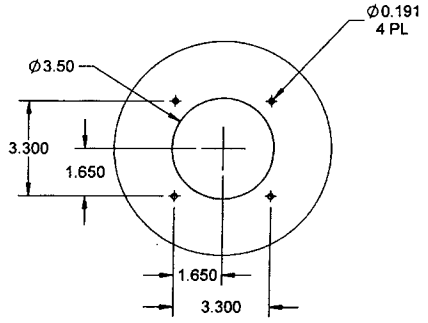


AUXILIARY VIEW S-S B7-17
SECTION S'-S' OPPOSITE
SCALE 2X

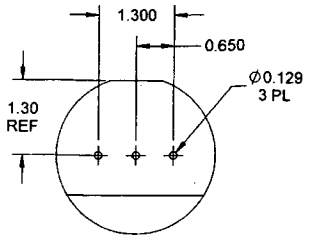
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MFG. APPR.		TITLE OUTBOARD CEILING PANELS SCALE NTS
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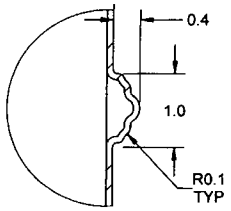
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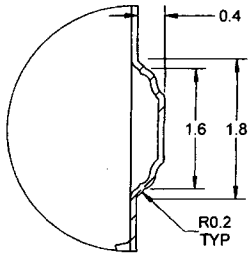
B DETAIL D B4-13 B3-14 B5-15 B5-16
SCALE 2X



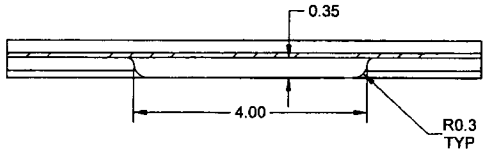
DETAIL E C7-13 B6-14 C6-15 B5-16
SCALE 4X



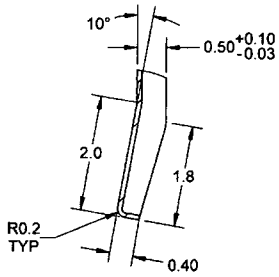
DETAIL L B2-17 B4-17 C5-17 C7-17
SCALE 1.5X



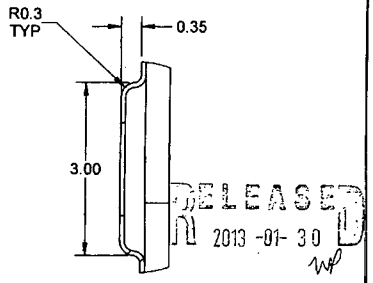
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SCALE 1.5X



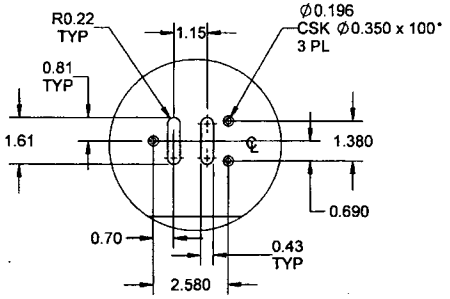
SECTION I-I B5-16
SCALE 4X



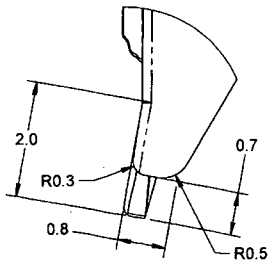
DETAIL O D2-17 D3-17 B5-17
SCALE 2X



DETAIL P C2-17
SCALE 4X



DETAIL Q C5-16
SCALE 2X



DETAIL N B2-13
SCALE 2X

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CHECKED		SHEET 18 OF 18
MFG. APPR.		TITLE OUTBOARD CEILING PANELS SCALE NTS
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